



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043**Job Sheet 196261****Part No:** D5425-043**Job Qty:** 1 pcs**Part Name:** Float Skidtube Assembly**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 6/10/19**Job Tracking No:****Due Date:** 7/30/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/30/19		0.00	8.24	Skidtubes - 1		TF MFG
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs	7/30/19		1.00	22.77	HAAS - 1 - B4B		M.M. 2019/07/27
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs	7/30/19		0.00	0.00	QC 2 - 1		DAS 64 9-89
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		

**Container No:** S193187**Part:** D5425 - 043**Job No:** 196261**Serial No/Batch:** S193187**Revision:** B**Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Email: sales@dartaero.com
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Date: 06/24/19

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					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	MM. 2019/07/02
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					140 QC 8	1 pcs
QC 8 - 14						
QC 8 - 17						
QC 8 - 20						
QC 8 - 25						
QC 8 - 3						
QC 8 - 32						
QC 8 - 33						
QC 8 - 35						
QC 8 - 39						
QC 8 - 4						
QC 8 - 44						
QC 8 - 45						
QC 8 - 49						
QC 8 - 58						
QC 8 - 8	B.e 19-07-23					
QC 8 - 9						
QC 8 - 68						
QC 8 - 67						
QC 8 - 1 (A)						
QC 8 - 47						
QC 8 - 40						
QC 8 - 52						
QC 8 - 23						
QC 8 - 57						
150 Handfinish - 1-1 Chemical-B4B	1 pcs	7/30/19	0.00	0.24	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	TW
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 -	

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64
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				B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
160 QC 7	1 pcs	7/30/19	0.00 0.00	QC 7 - 10		
				QC 7 - 13		
				QC 7 - 14		
				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18		
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34		
				QC 7 - 36		
				QC 7 - 37		
				QC 7 - 41		
				QC 7 - 47		
				QC 7 - 48		
				QC 7 - 51		
				QC 7 - 58		
				QC 7 - 59		
				QC 7 - 60		MBG
				QC 7 - 9		
				QC 7 - 68		
				QC 7 - 50		
				QC 7 - 67		
				QC 7 - 40		
				QC 7 - 24		
				QC 7 - 43		
170 Skidtubes - Bend - 2 - B4B	1 pcs	7/30/19	0.50 2.63	Skidtubes - Bend - B4B		MBG DD
180 QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BB
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		

						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
190	Skidtubes - 2 - B4B	1 pcs	7/30/19	0.00	8.24	Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	MOG
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
200	QC 5	1 pcs	7/30/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
210	Handfinish - 6-1- Touch Up- B4B	1 pcs	7/30/19	0.00	0.24	Handfinish - 6 - 1 - B4B	
						Handfinish - 6 - 2 - B4B	
						Handfinish - 6 - 3 - B4B	SA JUL 30 2019
						Handfinish - 6 - 4 - B4B	
						Handfinish - 6 - 5 - B4B	
						Handfinish - 6 - 6 - B4B	
						Handfinish - 6 - 7 - B4B	
						Handfinish - 6 - 8 - B4B	
						Handfinish - 6 - 9 - B4B	
						Handfinish - 6 - 10 - B4B	
						Handfinish - 6 - 11 - B4B	
						Handfinish - 6 - 12 - B4B	
						Handfinish - 6 - 13 - B4B	
						Handfinish - 6 - 14 - B4B	
						Handfinish - 6 - 15 -	

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				B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
220 QC 7	1 pcs	7/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	<i>M. Lajeunesse</i>
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
230 Skidtubes - 3 - B4B	1 pcs	7/30/19	0.00 8.24	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	<i>M. Lajeunesse</i>
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
240 QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	<i>QC 5 - 18</i>
				QC 5 - 19	<i>QC 5 - 19</i>
				QC 5 - 22	<i>QC 5 - 22</i>
				QC 5 - 24	<i>QC 5 - 24</i>
				QC 5 - 3	<i>AUG 07 2019</i>
				QC 5 - 43	
				QC 5 - 49	

						QC 5 - 51	
						QC 5 - 58	DAS
						QC 5 - 68	AUG 0 1 201968
						QC 5 - 9	9-89
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
250 Handfinish - 6-2- Touch Up- B4B	1 pcs	7/30/19	0.00	0.33	Handfinish - 6 - 1 - B4B		
					Handfinish - 6 - 2 - B4B		
					Handfinish - 6 - 3 - B4B	AUG 0 1 2019	
					Handfinish - 6 - 4 - B4B		
					Handfinish - 6 - 5 - B4B		
					Handfinish - 6 - 6 - B4B		
					Handfinish - 6 - 7 - B4B		
					Handfinish - 6 - 8 - B4B		
					Handfinish - 6 - 9 - B4B		
					Handfinish - 6 - 10 - B4B		
					Handfinish - 6 - 11 - B4B		
					Handfinish - 6 - 12 - B4B		
					Handfinish - 6 - 13 - B4B		
					Handfinish - 6 - 14 - B4B		
					Handfinish - 6 - 15 - B4B		
					Handfinish - 6 - 16 - B4B		
					Handfinish - 6 - 17 - B4B		
					Handfinish - 6 - 18 - B4B		
					Handfinish - 6 - 19 - B4B		
					Handfinish - 6 - 20 - B4B		
					Handfinish - 6 - 21 - B4B		
					Handfinish - 6 - 22 - B4B		
					260 QC 7	1 pcs	7/30/19
QC 7 - 13							
QC 7 - 14							
QC 7 - 15							
QC 7 - 17							
QC 7 - 18							
QC 7 - 19							
QC 7 - 2							
QC 7 - 28							
QC 7 - 3							
QC 7 - 30							
QC 7 - 34							
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				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	AB 19-8-3
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
270 Spray Paint - 2 - B4B	1 pcs	7/30/19	0.00 0.50	Spray Paint - 1 - B4B	AB 19-8-3
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
280 QC 14	1 pcs	7/30/19	0.00 0.00	QC 14 - 15	AB 19-8-3
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
282 Outsource - 11 - Paint	1 pcs	7/30/19		ATE003-VC	2
284 Packaging 2-1 - Receive - B4B	1 pcs	7/30/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	

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						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
286 QC 6	1 pcs	7/30/19	0.00	0.00		QC 6 - 9	
						QC 6 - 68	
						QC 6 - 61	
						QC 6 - 40	
290 Handfinish - 4-1-Assembly-B4B	1 pcs	7/30/19	0.00	0.24		Handfinish - 4 - 1 - B4B	14-8-8
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
300 QC 5	1 pcs	7/30/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	

				QC 5 - 40	
310 Packaging 3-1 - Stock - B4B	1 pcs	7/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
320 QC 21 - SA	1 pcs	7/30/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-50

AUG 07 2019

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Deburr ends as per Dwg.
 Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: B FOLIO REV: AA 2-Deburr as per Dwg.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 150 - 1-Scrub inside of tube with medium scotchbright.
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - 1-Bend Aft end of tube as per Dwg. and Folio 4.3. Insert Bending mandrel DT 10328 at 20.0" from aft end. Use buggy A,B,C. to stabilize tube. HEIGHT 4.3 2-Bend Forward end of tube as per Dwg. and Folio 7.375. Insert Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C To stabilize tube. HEIGHT 7.375 3-Record dimensions on work order.
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - 1-Drill remaining holes of DETAIL M, N, P. USING DT10340 A,B,C,D 2-Open holes to finished size as per Dwg. 3-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.
 200 - (QC5- Inspect part completeness to step on W/O)
 220 - (QC7-Inspect Chemical Conversion Coat)
 230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B Start Time: Finish Time: ***CURE TIME 6HRS. BEFORE PROCEEDING TO NEXT STEP*** 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Touch up alodine) ***DO NOT SUBMERGE TUBE IN DEOXODIZER***
 260 - (QC7-Inspect Chemical Conversion Coat)
 270 - (Spray Paint / NDT Room) ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5198114 2-PAINT AS PER DWG AND

QSI005 4.2.2.4 PAINT BATCH: 5198581**280** - (QC14- Inspect Spray Paint)**282** - ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT

BATCH: _____

284 - C OF C IS REQUIRED**290** - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B 516335 Exp: 19-12-9Start time: _____ Finish time: _____ 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon B M133 620**300** - (QC5- Inspect part completeness to step on W/O)**310** - (Identify as per dwg & Stock Location: _____)**320** - (QC21- Final Inspection - Work Order Release)**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 pcs (1 ea)	110-Skidtubes - 1	<u>5187596</u>
D5518-1	Crossbolt Spacer	18 pcs (18 ea)	230-Skidtubes - 3 - B4B	<u>5183903</u>
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B	<u>5187624</u>
AN3C5A	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5192141</u>
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>F164009</u>
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5199347</u>
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5200349</u>
NAS1149C0332R	Washer	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5193136</u>

Job Allocations

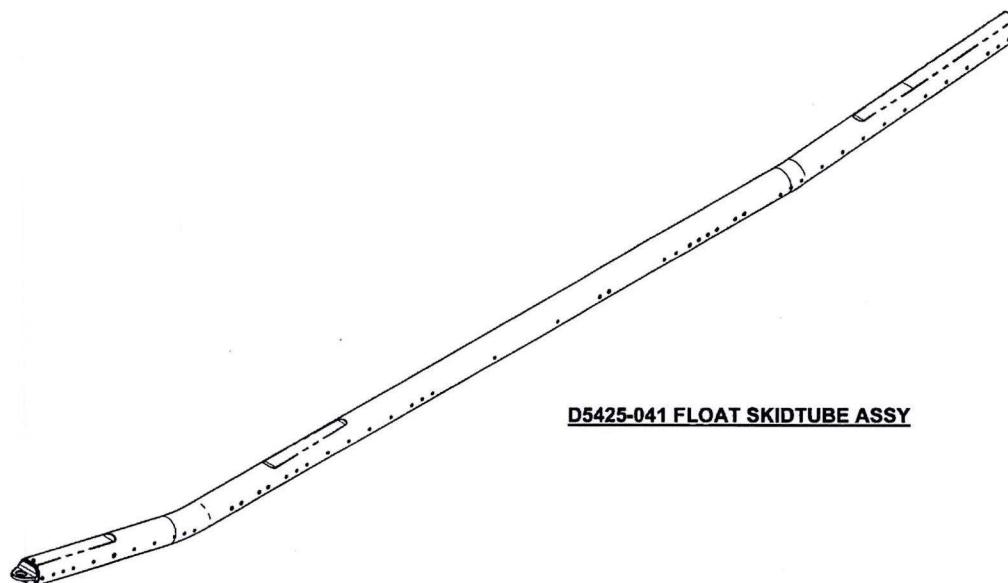
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D6028-195	1	15	0
230-Skidtubes - 3 - B4B	D5512-1	12	118	0
	D5518-1	18	236	0
290-Handfinish - 4-1-Assembly-B4B	AN3C5A	6	1,084	0
	D3672-1	6	1,669	0
	D5483-041	1	10	0
	D5484-041	1	9	0
	NAS1149C0332R	6	2,780	0

Part Specifications

Specifications could not be found.

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QTY -041	P/N	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER



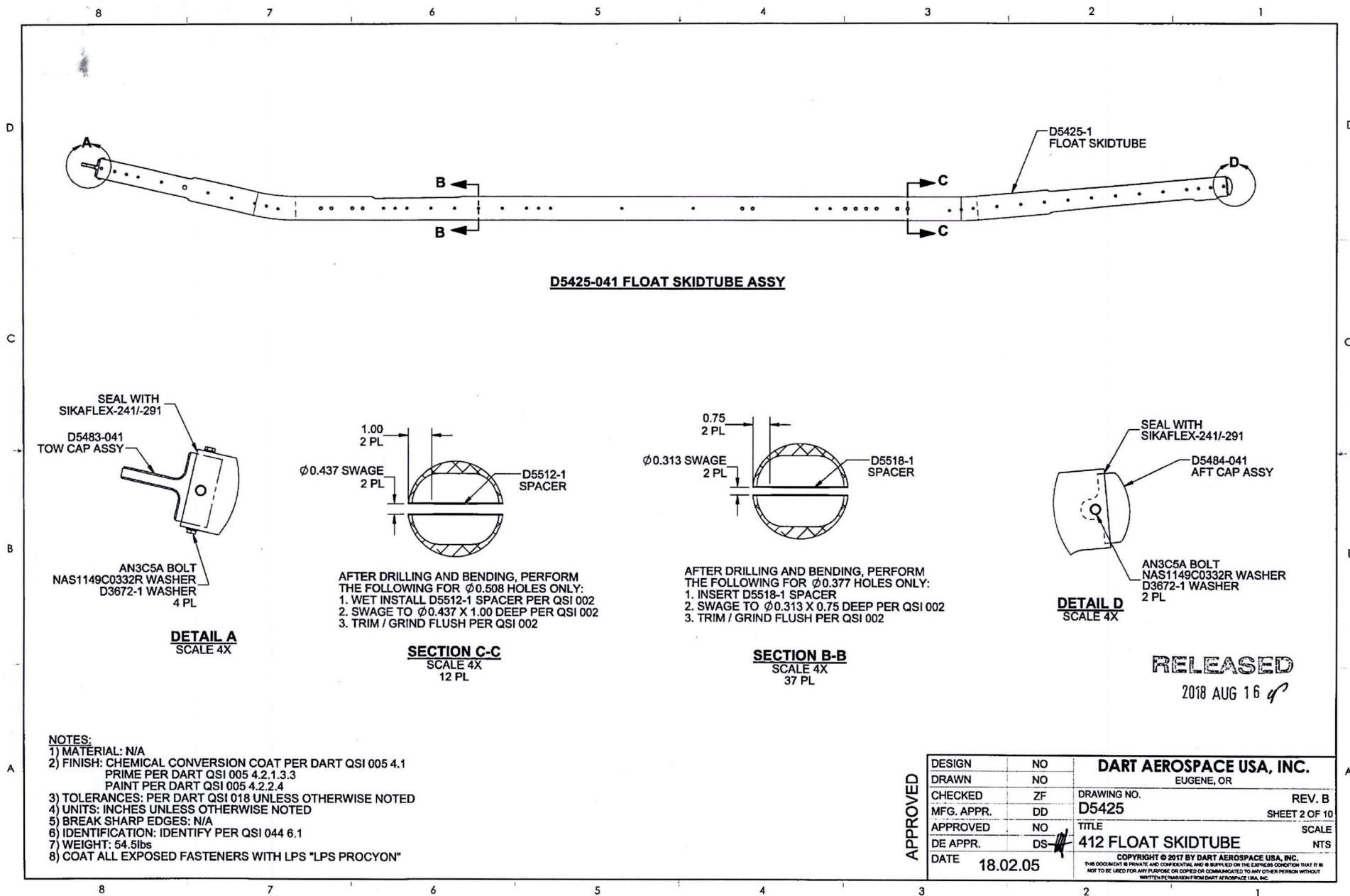
D5425-041 FLOAT SKIDTUBE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196261 MJS
190671

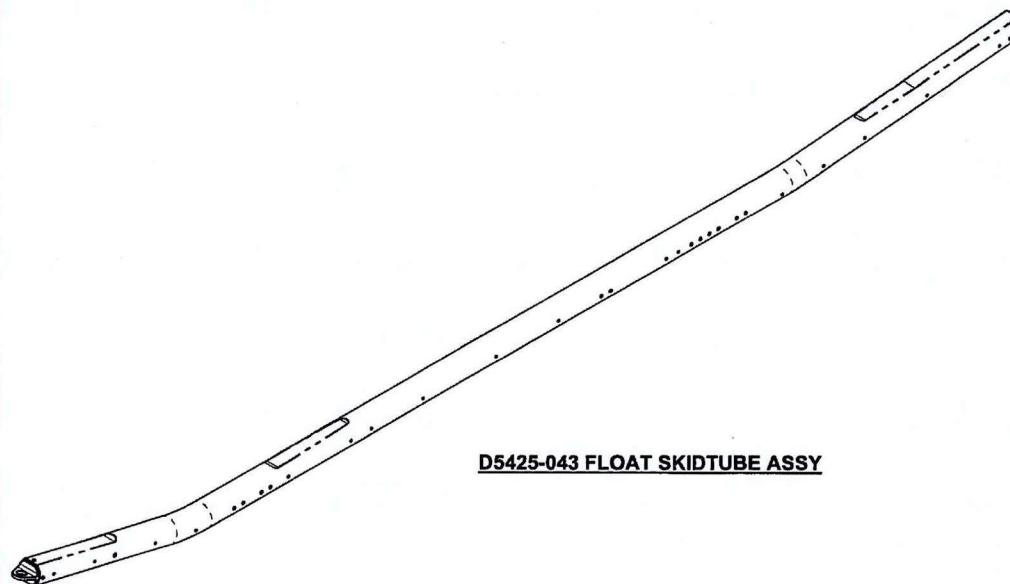
RELEASED
2018 AUG 16
ECN 18-736

B	CHANGE HOLE SIZE TO IMPROVE OFF-AXIS SWAGING IN SHEETS 5 AND 6 (NCR18-6741). PICTORIAL UPDATE DUE TO CHANGES IN D5483-1.	NO	18.02.05
A	NEW ISSUE	NO	17.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 1 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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APPROVED



QTY -043	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
18	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER

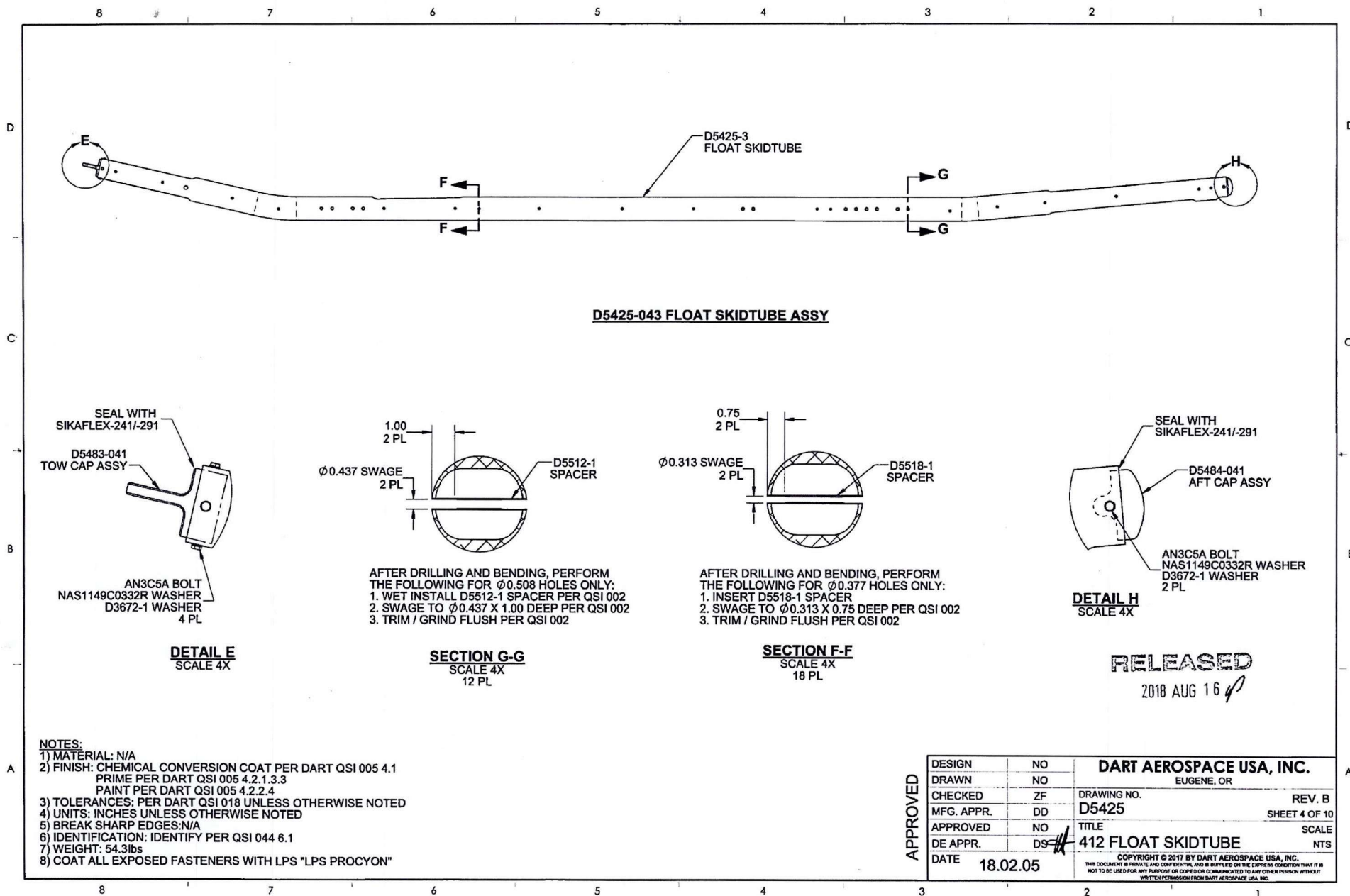


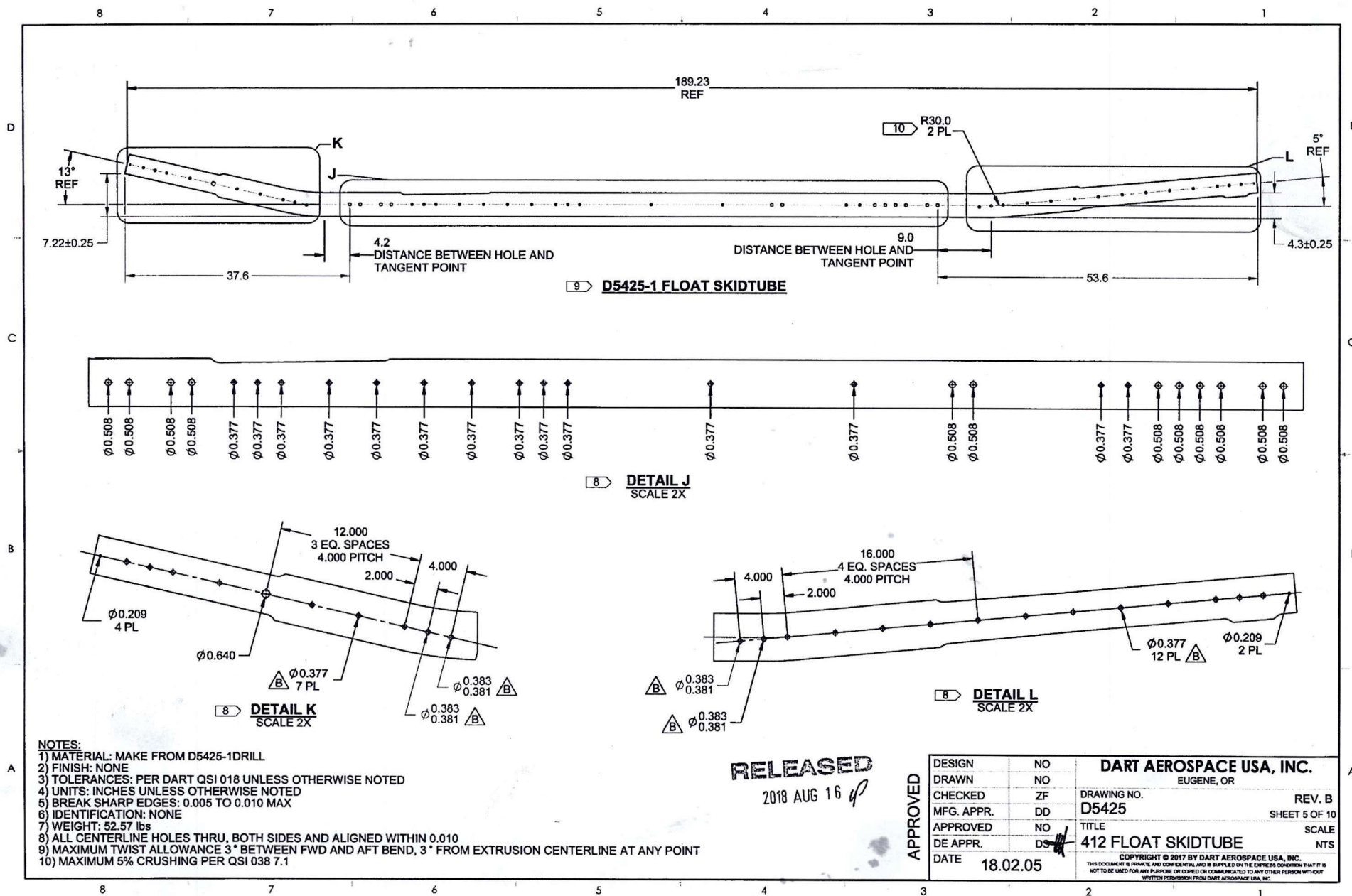
D5425-043 FLOAT SKIDTUBE ASSY

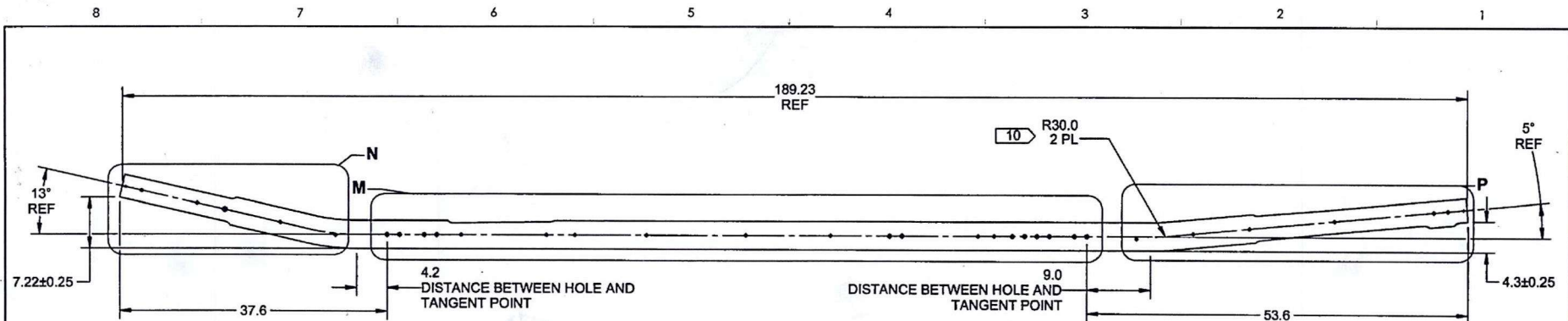
RELEASED

2018 AUG 16 *47*

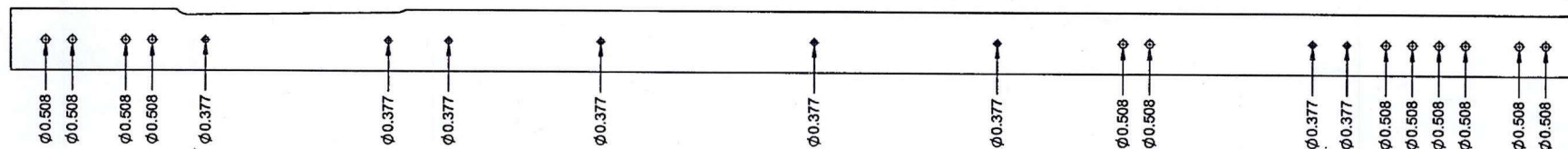
APPROVED	DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	NO		
	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 3 OF 10
	APPROVED	NO	TITLE	SCALE
	DE APPR.	D5	412 FLOAT SKIDTUBE	NTS
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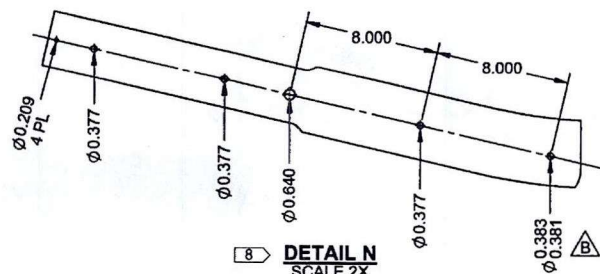




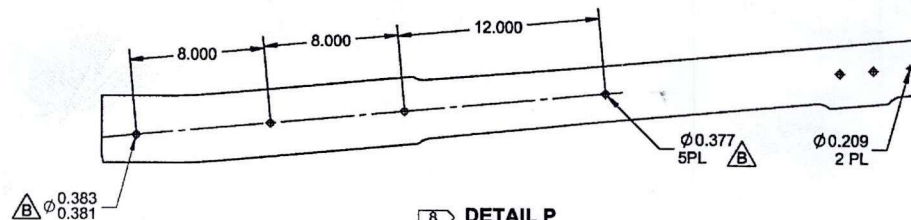
9 D5425-3 FLOAT SKIDTUBE



8 DETAIL M
SCALE 2X



8 DETAIL N
SCALE 2X



8 DETAIL P
SCALE 2X

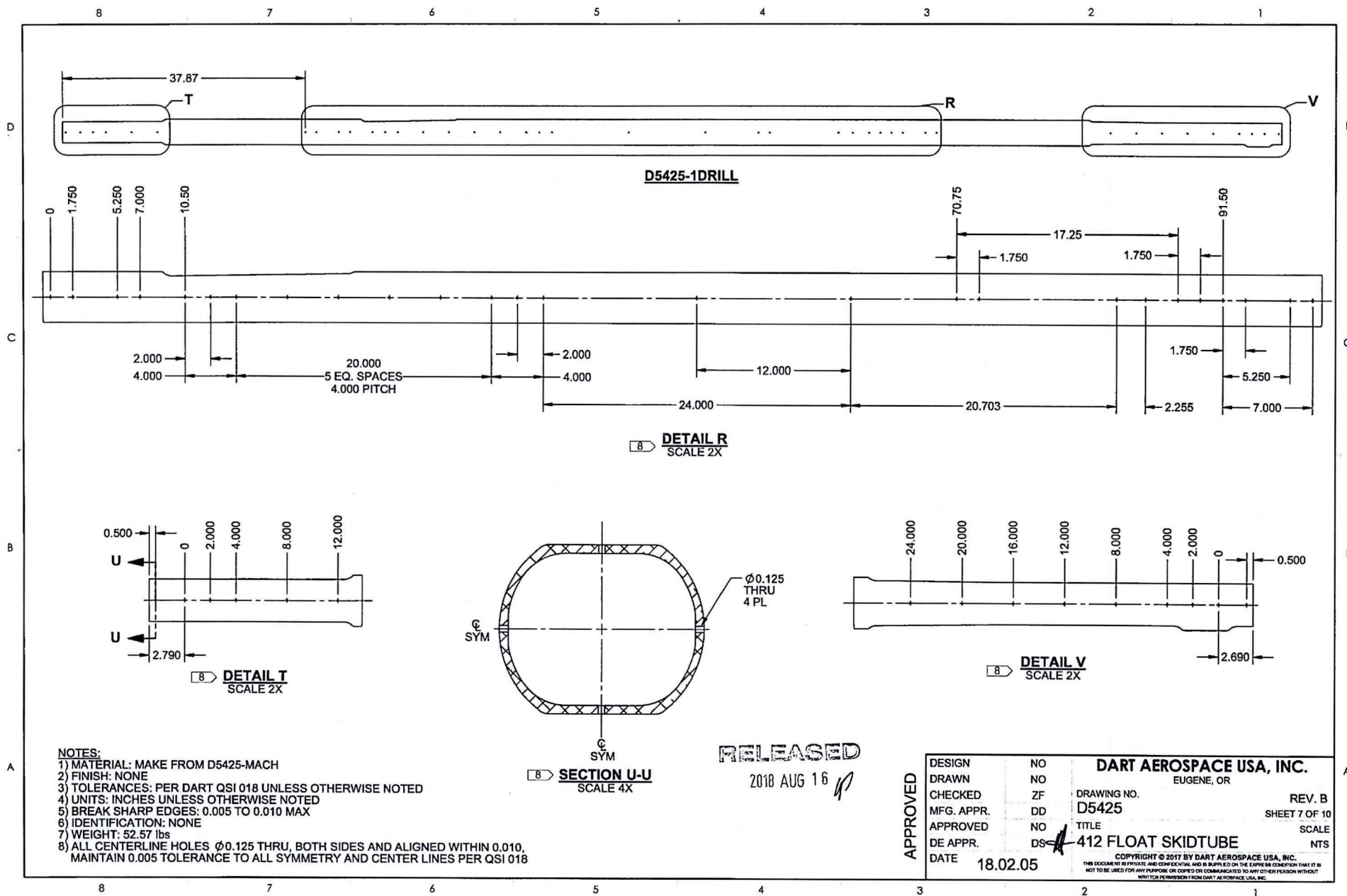
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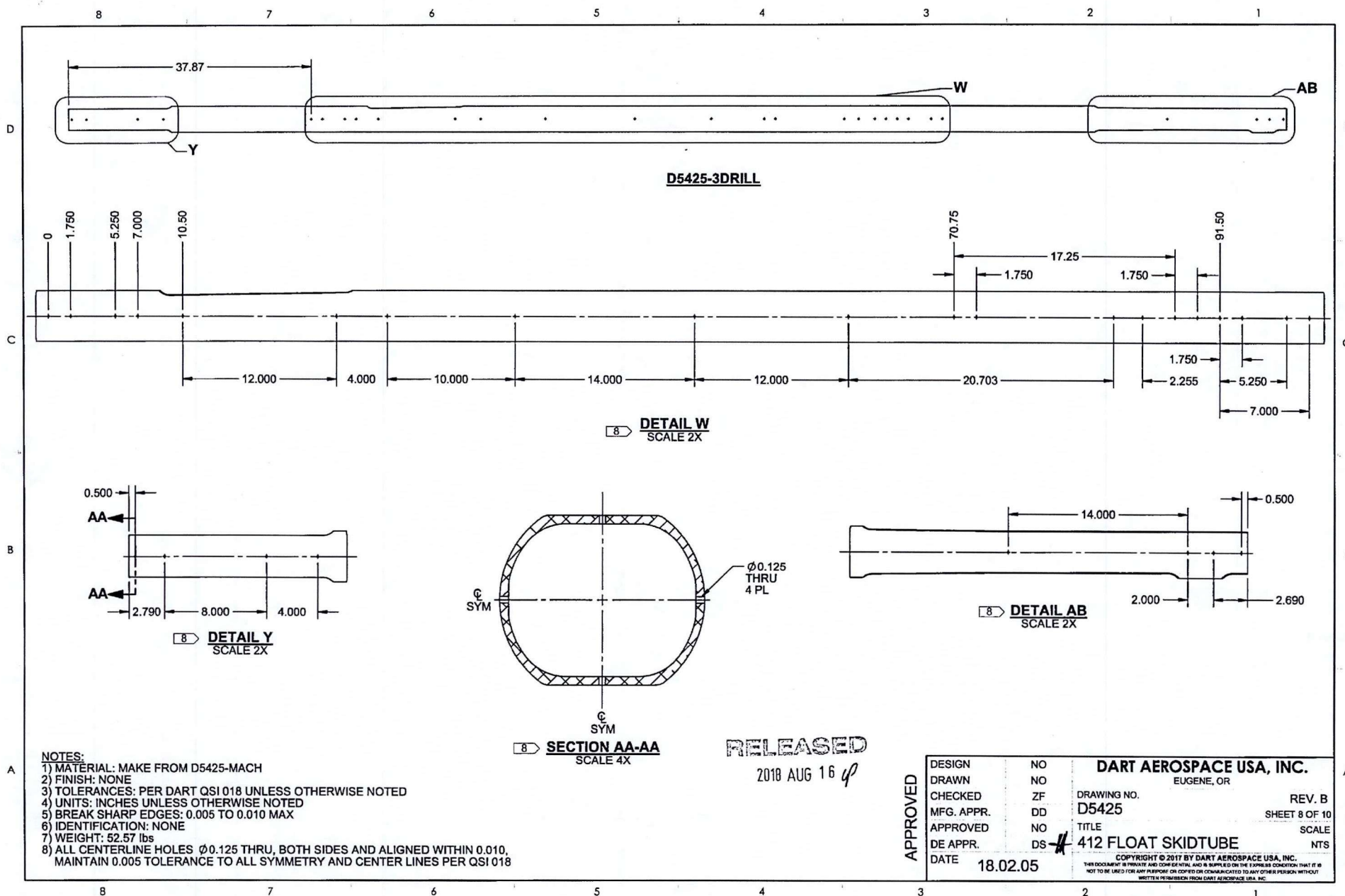
- 1) MATERIAL: MAKE FROM D5425-3DRILL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 52.57 lbs
- 8) ALL HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
- 9) MAXIMUM TWIST ALLOWANCE 3" BETWEEN FWD AND AFT BEND, 3" FROM EXTRUSION CENTERLINE AT ANY POINT
- 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

RELEASED

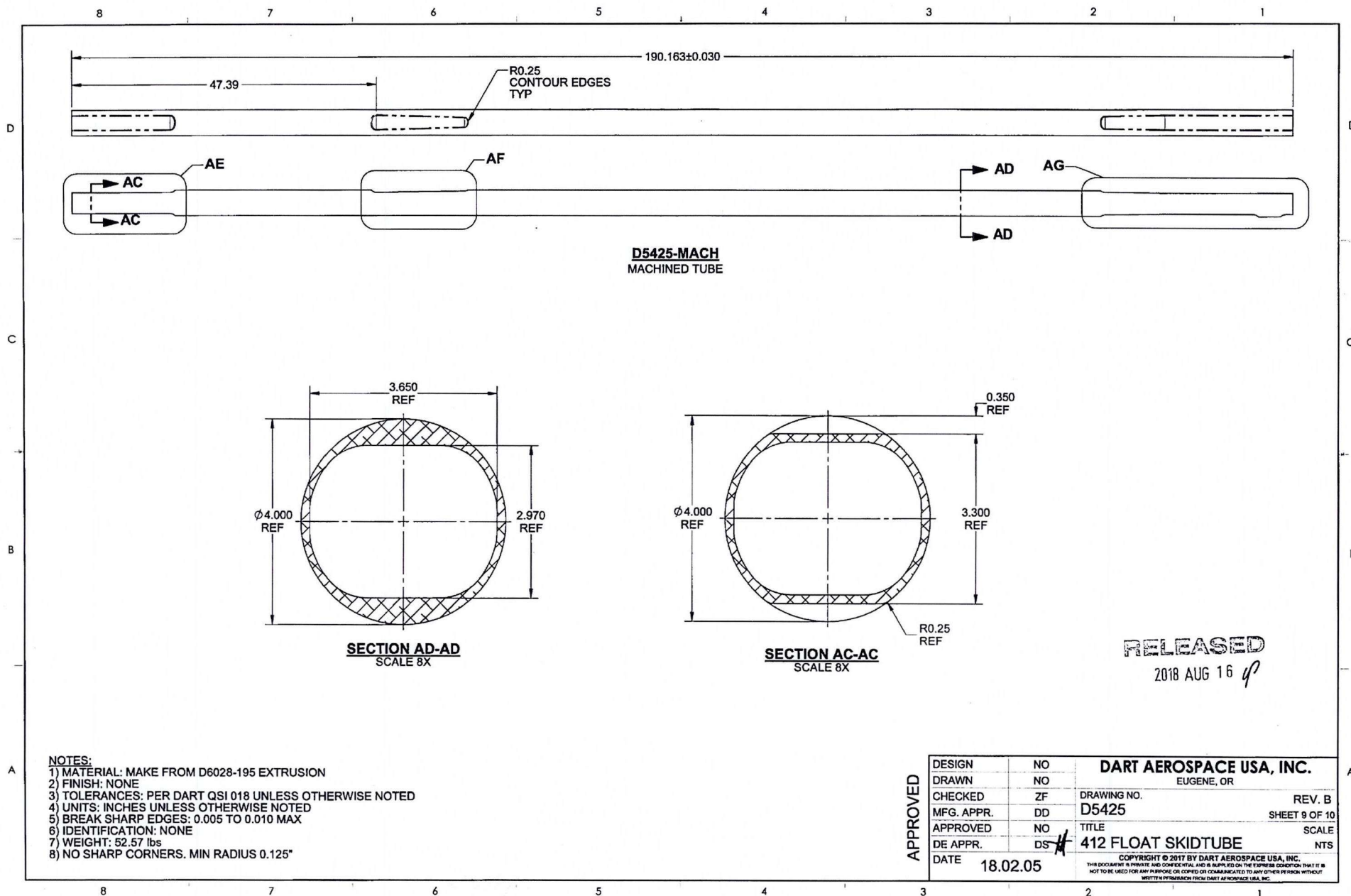
2018 AUG 16

APPROVED	DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	REV. B SHEET 6 OF 10 SCALE NTS
	DRAWN	NO		
	CHECKED	ZF		
	MFG. APPR.	DD		
	APPROVED	NO		
DE APPR.	DS		DRAWING NO. D5425	TITLE 412 FLOAT SKIDTUBE
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DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 8 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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2018 AUG 16 *4*

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 10 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DSC	412 FLOAT SKIDTUBE	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			

DART AEROSPACE LTD		Work Order: 196261
Description: 412 FLOAT SKIDTUBE		Part Number: D5425-043
Inspection Dwg: D5425 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- .010	0.500	✓		Mxn-04	Vern
2.790	+/- .010	2.790	✓		Dial Ind.	HAAS4
10.790	+/- .010	10.790	✓		"	"
14.790	+/- .010	14.790	✓		"	"
43.120	+/- .010	43.116	✓		"	"
44.870	+/- .010	44.866	✓		"	"
48.37	+/- .010	48.366	✓		"	"
60.37	+/- .010	60.366	✓		"	"
64.37	+/- .010	64.366	✓		"	"
74.37	+/- .010	74.366	✓		"	"
123.328	+/- .010	123.324	✓		Tape	ref.
125.87	+/- .010	125.866	✓		"	"
129.87	+/- .010	129.366	✓		"	"
131.12	+/- .010	131.116	✓		"	"
134.62	+/- .010	134.616	✓		"	"
136.37	+/- .010	136.366	✓		"	"
0.500	+/- .010	0.500	✓		Dial Ind.	HAAS4
2.690	+/- .010	2.690	✓		"	"
4.69	+/- .010	4.690	✓		"	"
18.69	+/- .010	18.690	✓		"	"
15.24	+/- .030	15.240	✓		"	"
R1.0	+/- .100	R1.000	✓		R-6	ref.
0.350	+0.000 / - .020	0.338	✓		Dial Ind.	HAAS4
0.350	+0.000 / - .020	0.340	✓		"	"
R1.0	+/- .100	R1.000	✓		R-6	ref.
13.71	+/- .030	13.710	✓		Dial Ind.	HAAS4
0.152	+/- .015	0.142	✓		"	"
0.250	+/- .015	0.240	✓		"	"
9.35	+/- .030	9.35	✓		Vern	CVC-02
0.350	+0.000 / - .020	0.344			Dial Ind.	HAAS4
20.00	+/- .030	20.00	✓		"	"
0.250	+/- .015	0.241			"	"

Measured by: MM. 2019/	Checked by: B.	QC Inspector:
Date: MM. 2019/07/25	Date: 19-07-23	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

